



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1712

Job Sheet 211334



Part No: 647.1712

Job Qty: 24 pcs

Part Name: Gusset



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/14/20

Job Tracking No:

Due Date: 8/10/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: 647.1700 REV.F IPP REV:A 12.10.04 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Waterjet - Flow - 1	24 pcs		7/28/20	0.17	2.64	Waterjet - Flow			20/07/28
120	QC 2	24 pcs		7/28/20	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			20/07/28
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
QC 2 - 8										
QC 2 - 66										
QC 2 - 64										
					Plex 7/14/20 8:13 AM Dart.Renwick.Jennifer					

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130 QC 8	24 pcs	7/28/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Small Fab - Brake NC - B4B	24 pcs	7/29/20	0.25 4.29	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	24 pcs	7/29/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	

DAS

2 8 2020 40
9-89

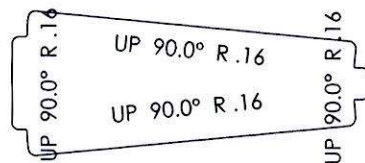
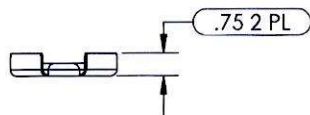
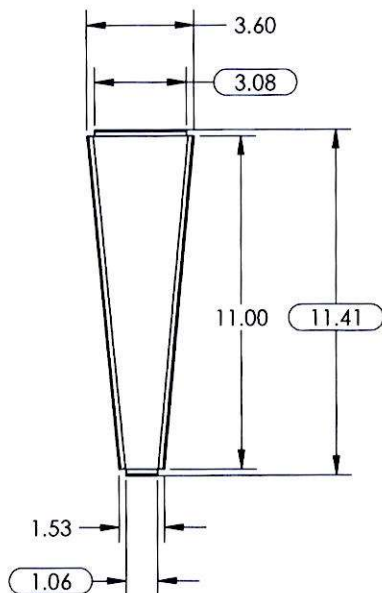
AUG 0 4 2020

				QC 5 - 40	AUG 05 2020
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
160 Outsource - 4 - Anodize	24 pcs	8/10/20		ATG001-VC 8	2020-08-11
170 Packaging 2-1 - Receive - B4B	24 pcs	8/10/20	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	AUG 20 2020
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	DAS 8/24/2020
				Packaging 2 - 23 - B4B	SEP 08 2020
				Packaging 2 - 24 - B4B	9-89
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
180 QC 6	24 pcs	8/10/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	SEP 01 2020
				QC 6 - 81	40
				QC 6 - 82	9-89
210 Packaging 3-1 - Stock - B4B	24 pcs	8/10/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	

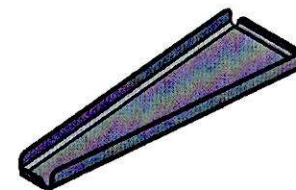
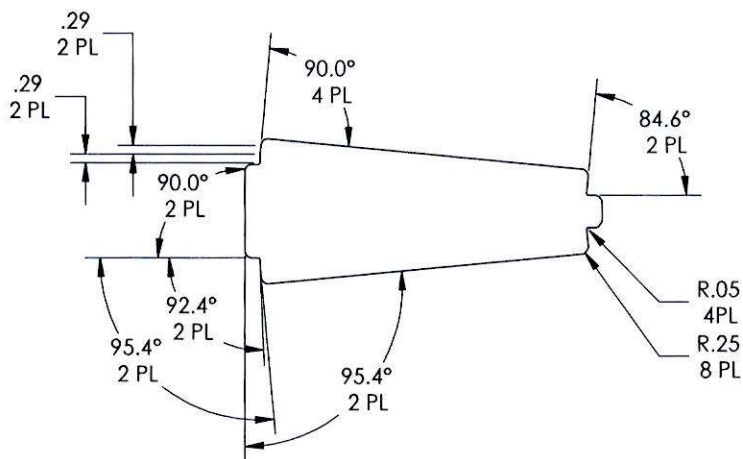
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	DAS 84
				Packaging 3 - 23 - B4B	SEP 08 2020
				Packaging 3 - 24 - B4B	9-89
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
220 QC 21 - SA	24 pcs	8/10/20	0.00 0.00	QC 21 - SA - 21	CCK 831
				QC 21 - SA - 70	
				QC 21 - SA - 9	DAS 77
				QC 21 - SA - 77	SEP 8 2020 9-89
Part Op 110 - 1-Cut as per Dwg ****Debur by hand only***** Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Form as per dwg) 150 - (QC5- Inspect part completeness to step on W/O) 160 - Issue P/O to ATG : <u>46879</u> Hard Anodize, Color Black and Prime as per Dwg 647.1700 Rev. E 170 - (Receive & Inspect for Damage & Mat'l Certs) 180 - (QC6- All purchased or subcontracted products) 210 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** 220 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M7075T6S.050	7075-T6 Sheet .050	14.3280 sf (.597 ea)	110-Waterjet - Flow - 1	S155922	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Waterjet - Flow - 1	M7075T6S.050	14	23	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Gusset	3.080Inches ± 0.005	3.085 3.075	3.083	
2	Gusset	1.060Inches ± 0.005	1.065 1.055	1.064	
3	Gusset	0.050Inches ± 0.005	0.055 0.045	0.049	

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FLAT PATTERN



647.1712

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 211334

ORIGINAL DATE 12-12-78		DESIGNED J. GARDNER		CHECKED P. BRAVO	
DRAWN BY J. GARDNER		APPROVED P. BRAVO		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		DATE B		CAGE CODE 07M16	
		DWG. NO. 647.1700		REV. F	
		SCALE NONE		SHEET 4 OF 7	

DART AEROSPACE
3030 ENTERPRISE CT., SUITE A
VISTA, CA. 92081
(760)724-5300

SKID DEFLECTOR ASSY

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Date :	Sequence #:	QTY Affected :	MRB (QS1042)
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Description Work Order Deviation	Disposition	
		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:				



Container No: S290466



Part: 647.1712

Job No: 211334

Serial No/Batch: S290466

Revision: Rev.F

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA

TEL.: 1 813 832-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 07/28/20



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046879



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046879
PO Date: 8/11/20
Due Date: 8/21/20
Purchase Order
Revision:
Revision Date:
Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	211687	D2348	D2348 Rev C	Wearplate (Key Way) : Various STC's Issue P/O: Black Anodize per Dwg D2348 Rev. C	Firmed X30	-	8/21/20	30 pcs	0 pcs	30 pcs	\$4.87/pcs	\$146.10
2	211896	D4703-043	D4703 Rev C	Lock Pin Base : Various STC's Issue P/O to ATG: -HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 -As Per Dwg D4703 -Material type: 6061T6 -Certificate of Conformity is required	Firmed X20	-	8/21/20	20 pcs	0 pcs	20 pcs	\$3.62/pcs	\$72.40
3	211333	647.1711	647.1700 REV.F	Plate : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed X13	-	8/21/20	13 pcs	0 pcs	13 pcs	\$31.17/pcs	\$405.21
4	211334	647.1712	647.1700 Rev.F	Gusset : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 647.1700 Rev. E	Firmed X24	-	8/21/20	24 pcs	0 pcs	24 pcs	\$13.57/pcs	\$325.68

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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046879



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	211962	646.3110	646.3100 Rev N/C	Channel : Various STC's Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed X12	-	8/21/20	12 pcs	0 pcs	12 pcs	\$19.02/pcs	\$228.24
									AUG 20 2020			
6	211967	650.9201	650.9200 Rev A1	Eyelet Bracket Assembly : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed X16	-	8/21/20	16 pcs	0 pcs	16 pcs	\$7.52/pcs	\$120.32
									AUG 20 2020			
7	211963	646.3210	646.3200 Rev NC	Support : Various STC's Issue P/O to ATG : 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed X12	-	8/21/20	12 pcs	0 pcs	12 pcs	\$15.27/pcs	\$183.24
									AUG 20 2020			
8	211112	RB H4713-1	RB H4713 Rev F	Drain Hose Body -Issue P/O to ATG -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RB910-0020-1 Rev. 2	Firmed X4	-	8/21/20	4 pcs	0 pcs	4 pcs	\$4.87/pcs	\$19.48
									AUG 18 2020			
9	211514	RBT18609-1	RBT18609 Rev 4A	Top Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material; 6061 -Certificate of Conformity is required	Firmed X2	-	8/21/20	2 pcs	0 pcs	2 pcs	\$4.87/pcs	\$9.74
									AUG 18 2020			



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046879



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
10	211515	RBT18609-2	RBT18609 Rev 4A	Lower Body Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material; 6061 -Certificate of Conformity is required	Firmed <i>X2</i>	-	8/21/20	2 pcs	0 pcs	2 pcs	\$4.87/pcs	\$9.74

Grand Total: \$1,520.15

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Sherin

Plex 8/17/20 3:01 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920671

Date: 18-Aug-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
13 ea	Part: 647.1711 Plate Hard Anodize, Type III, Class2, Black (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Batch/Lot# 5265778 Expiry Date: 8/23/21 Job: 27940 Line: 3 PO: POHB046879		Rev: F
24 ea	Part: 647.1712 Gusset Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5265778 Expiry Date: 8/23/21 Job: 27941 Line: 4 PO: POHB046879		Rev: F
12 ea	Part: 646.3110 Channel Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 5265778 Expiry Date: 8/23/21 Job: 27942 Line: 5 PO: POHB046879		Rev: NC
16 ea	Part: 650.9201 Eyelet Bracket Assembly		Rev: A1
Made in Canada.			



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920671

Date: 18-Aug-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

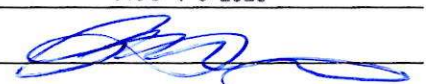
Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 5265778 Expiry Date: 8/23/21 Job: 27943 Line: 6 PO: POHB046879		
12 ea	Part: 646.3210 Rev: NC Support Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 5265778 Expiry Date: 8/23/21 Job: 27944 Line: 7 PO: POHB046879		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>AUG 18 2020</u> Certified Signature:  Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			